

Date: Wednesday, 2/15/2006 3:45:50 PM  
 User: Kim Johnston

### Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HANDLE WELDMENT		
Job Number	: 25825 - 1					
Estimate Number	: 10333					
P.O. Number	: N/A			Part Number	: D2530	
This Issue	: 2/15/2006		S.O. No. : N/A	Drawing Number	: D2530 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A		Type : SMALL /MED FAB	Drawing Revision	: B	
Previous Run	: 24876			Material	: N/A	
Written By	: SEE COMMENT Below			Due Date	: 2/28/2006	
Checked & Approved By	: DPF 06.02.16			Qty:	20	Um: Each
Comment	Est Rev:E	Removed Purchasing	05-11-07	JLM		

#### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	25825A	LOCK PLATE
<b>Comment:</b> Sub-Component LOCK PLATE		
2.0	M304TR0750W049	304 RD Tube .750 x .049W
<b>Comment:</b> Qty.: 0.4809 f(s)/Unit Total : 9.6180 f(s) Material: 304/316 SS Seamless Tubing 0.75" OD x 0.049" wall(M304TR0.750W.049) Batch: M18983		
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1		

1-Cut to length as per Dwg D2536 SAD 06.02.18

2-Deburr SAD 06.02.18

4.0	D2534	Lock Plate	
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Pick: QTY Part # Description Batch 2 D2534 Lock Plate B24876A			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1			

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

CPL 06.02.20

1d

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  17 Date: 06/02/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 3:45:51 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DARU01 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 25825

Part Number: D2530

Job Number:



Seq. #: Machine Or Operation:

Description :

2-Deburr

6.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

U 06/02/20 (1)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FC 06/02/21

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S7183

R 06/02/22 (1)

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

QD 06/02/23 (1)

Job Completion



U 06.02.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

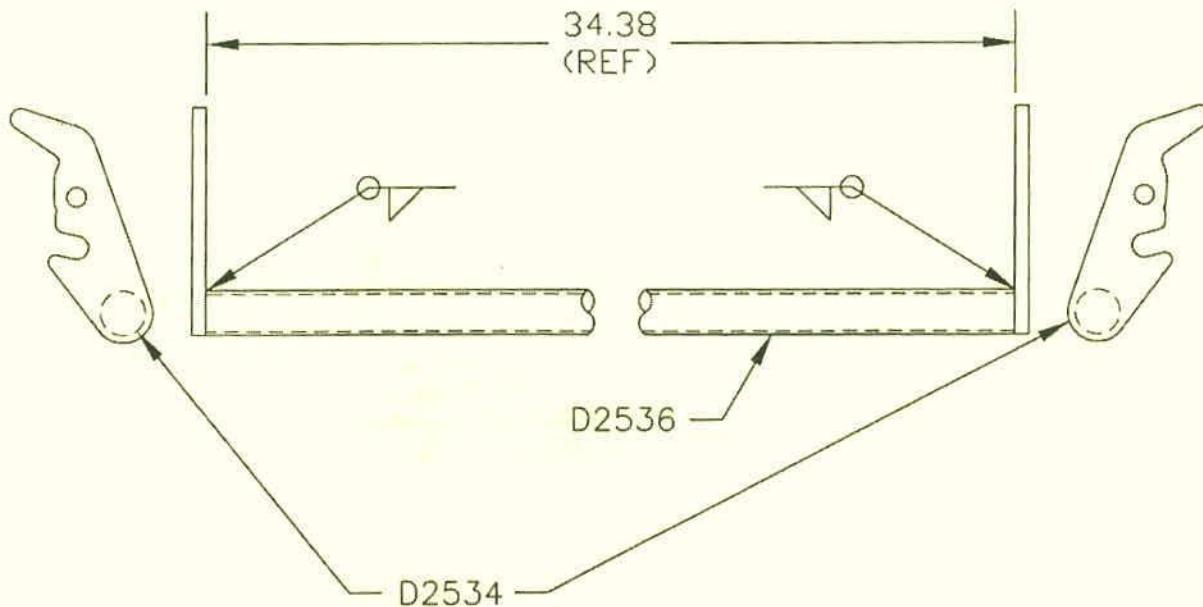
**DART**

DESIGN B. WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2530 REV. B SHEET 1 OF 1
DATE 04.12.14		TITLE HANDLE WELDMENT
A	96.06.18	SCALE NEW ISSUE
B	04.12.14	UPDATE NOTES AND DIMENSIONS

RELEASED

04.12.16 *[initials]*PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *25825*

